

Work Order ID 62750

Thursday, October 07, 2010 3:09:17 PM

Page 1

Item ID: D206-628-024

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step RH

Start Date: 10/7/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-07

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-024 CHG 003

Solutio

*for BG 10-11-12 (4)

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/11/12 SH42

120

0.00



QC- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Solutio

x4 RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-024

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Setup Start



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Item Name: Heli-Access-Step RH

Start Date: 10/7/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-024

Location: 71
PPP Rev: 9

10/11/10 40

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/11/10
ME
10-11-10

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Picklist Print

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Work Order ID: 62750

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A

Purchased

No

120

Each

1,650.000

3

12

BOLT

Location

Loc Qty

Loc Code

ST245

20

110139

20

ST303

42

115438

42

ST350

1588

114108

14

114416

12

114523

2

115300

560

115589

1000

AN4C14A

Purchased

No

120

Each

87.0000

4

16

Bolt

Location

Loc Qty

Loc Code

ST358

87

111902

17

115767

40

115835

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62750



Parent Item: D206-628-024



Parent Item Name: Heli-Access-Step RH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

120

Each

127.0000

8

32



Bolt



10/11/12sf

Location

Loc Qty

Loc Code

ST358

127

114442

1

115457

26

115835

100

32

AN960C10

NAS1149C0363

Purchased

No

120

Each

0.0000

3

12



WASHER,

AN960C416L

Purchased

No

120

Each

180.0000

24

96



WASHER



11/3644 10/11/12sf

11/14742 10/14/12sf

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

136

106785

10

107008

10

112828

75

69220

41

D2731-7

Manufactured

No

120

Each

39.0000

4

16



Mounting Lug



B62230 10/11/12sf (4x)

Location

Loc Qty

Loc Code

ST420

15

60996

15

ST470

24

61653

24

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Parent Item Name: Heli-Access-Step RH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D2732 Manufactured No

120 f

216.4157 2



Rubber Extrusion



8
10/14/10

Location

Loc Qty

Loc Code

ST412

216.415737

43118

2.5

56516

213.915737

8/10/10

(D2732-030) Cut (8) at 3.00"

D2842-042

Manufactured No

120 Each

2.0000 1



Step Assembly RH, 206 Float



4
B62751 10/11/10

Location

Loc Qty

Loc Code

FG

2

61046

2

120 Each

1.0000 2

D2844-1

Manufactured No



Arm



8 (4x)
B61452 B62754
10/11/10

Location

Loc Qty

Loc Code

ST265

1

52030

1

120 Each

9.0000 1

D2844-3

Manufactured No



Arm



4
10/11/10

Location

Loc Qty

Loc Code

ST265

9

61453

9

4

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Page 4

Work Order ID: 62750

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D3394-043

Manufactured No

120

Each

49.0000

4

16



Lug Assembly



B62667 10/11/10

Location

Loc Qty

Loc Code

ST420

19

60997

19

ST475

30

62005

30

MS21043-4

Purchased No

120

Each

783.0000

12

48



Nut



10/11/12

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

743

112492

25

113069

8

114523

410

114784

300

NAS1515H3

Purchased No

120

Each

98.0000

3

12



Washer



10/11/12 SP 60

Location

Loc Qty

Loc Code

ST277

98

111268

4

115675

94

12

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Shop Packet Print

Page 4

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Pieclist Print

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Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4L

Purchased

No

120

Each

456.0000

24

96

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

416

112492

11

114236

48

114265

357

10/11/12 SL(41)

96

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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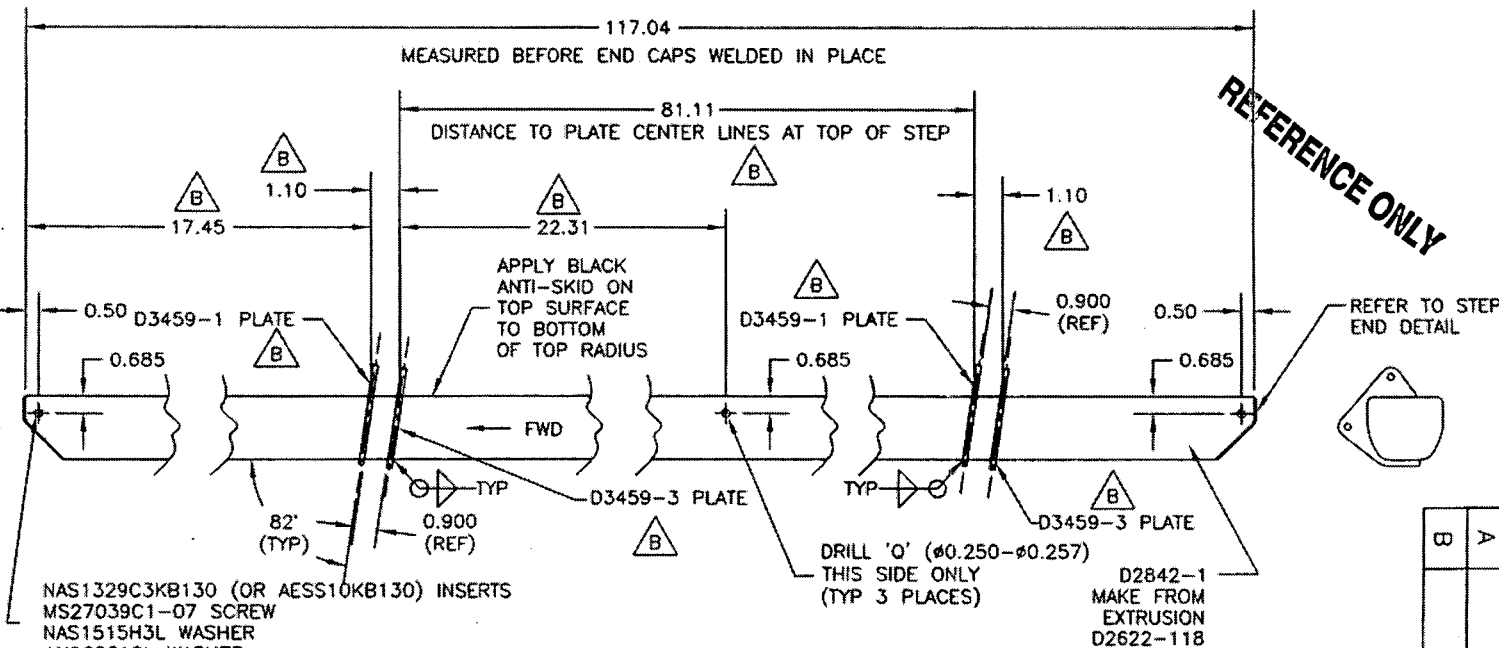
5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

DART

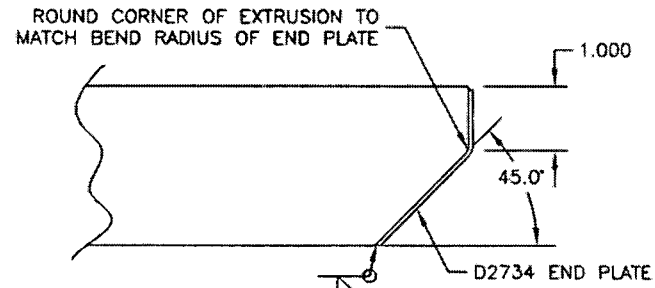
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
05.09.23	05.09.23	D2842
DATE	05.09.23	TITLE
		206L/407 FLOAT STEP ASSEMBLY
		NEW ISSUE
		RE-DESIGN, ADD D3459-1/-3
		SCALE
		NTS
		SHEET 1 OF 1
		REV. B



D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/11/14